



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4353-041
Job Sheet 175806



Part No: D4353-041

Job Qty: 4 ea

Part Name: Bearpaw Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/10/18

Job Tracking No:

Due Date: 4/24/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 11-04-12 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	4/23/18	4/23/18	0.00	0.00	Start Up Waterjet		OK 18/04/13
120	Waterjet	4 pcs	4/23/18	4/23/18	0.00	2.05	Waterjet1		OK 18/04/13
130	CNC Vertical Machining	4 pcs	4/23/18	4/23/18	0.98	10.81	HAAS1-4		WJ
140	QC	4 pcs	4/23/18	4/23/18	0.00	0.00	QC2 Machining-2		WJ
150	QC	4 pcs	4/23/18	4/23/18	0.00	0.00	QC8 Machining-2		OK 18/05/28
152	Packaging	4 pcs	4/23/18	4/23/18	0.00	0.00	Packaging1-5		SMB
153	Small Fab	4 pcs	4/24/18	4/24/18	0.00	0.36	Small Fab-6		SMB
154	QC	4 pcs	4/24/18	4/24/18	0.00	0.00	QC5		38
155	Packaging	4 pcs	4/24/18	4/24/18	0.00	0.00	Packaging3-2		DAS 9-89
190	QC21-SA	4 Ea	4/24/18	4/24/18	0.00	0.00	QC21		6 JUN 01 2018

Part Op 120 - Cut Blank as per D4353-1 File

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining. 2-Program batch number. Ensure that batch number reflects the W/O. 3-Machine as per Folio FB050 and Dwg. 4-Debur

153 - PRESS D4353-3 INSERT INTO BEARPAW

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4353-3	Bearpaw Insert	4 Ea (1 ea)	90-Start up Operation	137199
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	25.6000 sf (6.4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4353-3	4	6	0
	MUHMWB10	26	1,865	0

Part Specifications

Specifications could not be found.

Plex 4/10/18 4:01 PM Dart.Gagnon.Michelle



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Container No: S060980



Part: D4353-041

Job No: 175806

Serial No/Batch: S060980

Revision:

Inspector:

Date: 04/13/18

340
38
38

340
38
38

DART AEROSPACE LTD		Work Order:	175806
Description: Bearpaw		Part Number:	D4353-1
Inspection Dwg: D4353 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.38	+/-0.030	0.380	✓		Kt-05	verm.
7.375	+/-0.010	7.375	✓		" "	" "
12.50	+/-0.030	12.500	✓		TAPE	—
1.38	+/-0.030	1.380	✓		Kt-05	verm.
3.813	+/-0.010	3.813	✓		" "	" "
24.00	+/-0.030	24.00	✓		TAPE	—
10.09	+/-0.030	10.09	✓		CNC-02	verm.
1.00	+/-0.030	1.00	✓		Kt-05	verm.
6.150	+/-0.010	6.150	✓		" "	" "
3.038	+/-0.010	3.039	✓		Kt-05	verm.
6.563	+/-0.010	6.563	✓		" "	" "
9.250	+/-0.010	9.250	✓		" "	" "
27.00	+/-0.030	27.00	✓		TAPE	—
1.25	+/-0.030	1.250	✓		Kt-05	verm.
0.30 x 45°	+/-0.030	0.295x45	✓		" "	" "
1.38	+/-0.030	1.380	✓		" "	" "
0.63	+/-0.030	0.617	✓		Kt-01	m-10
0.95	+/-0.030	0.941	✓		V-11	" "
R0.25	+/-0.030	0.250	✓		R-G	—
0.70	+/-0.030	0.700	✓		Kt-05	verm.
0.07 x 45°	+/-0.030	0.064x45	✓		" "	" "
Ø0.650	+/-0.010	0.650	✓		" "	" "
Ø0.261	+0.006/-0.001	0.261	✓		" "	" "
0.400	+/-0.010	0.400	✓		" "	" "
4.750	+0.012/-0.000	4.750	✓		" "	" "
4.000	+0.012/-0.000	4.000	✓		" "	" "
5.75	+/-0.030	5.750	✓		Kt-05	verm.
0.63	+/-0.030	0.617	✓		" "	" "
0.57	+/-0.030	0.570	✓		" "	" "
0.25	+/-0.030	0.240	✓		Kt-05	verm.
0.45	+/-0.030	0.450	✓		" "	" "
0.06 x 45°	+/-0.030	0.060x45	✓		" "	" "
R0.25	+/-0.030	0.250	✓		R-G	—

Measured by: KJ	Audited by: J. H.	Preliminary Approval:
Date: 2018/05/25	Date: 18/05/28	Date:

Rev	Date	Change	Revised by	Approved
A	11.07.26	New Issue	KJ	